

Work Order ID 58236

Friday, April 30, 2010 1:01:01 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 4/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-4-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

A

100

Weld per dwg A/R S.S. rod Batch: 111679 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

Cpl 10.05.07

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

D 10.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/05/10



130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

=> 10/05/10

XL Ø

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 9:15AM

OVEN TEMPERATURE: 400°C

FINISH TIME: 9:45AM

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 10:00AM

OVEN TEMPERATURE: 400°C

FINISH TIME: 10:30AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 5/10/05/10 (D)

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EP 5/10/05/10 (D)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/05/10

(D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: G-A

0.00



Packaging

w/ 58312

Memo

0.00

Packaging

EP 10/05/10 @

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10 J

MF
10-5-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, April 30, 2010 1:01:01 PM

Page 1

Work Order ID: 58236

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	112.0000	6			

Location	Loc Qty	Loc Code
ST351	112	
111119	12	
114330	100	

AN960JD8 Washer	QSI 017	Purchased	No			150	Each	0.0000	2			
D2581 Mounting Bracket		Manufactured	No			100	Each	27.0000				

Location	Loc Qty	Loc Code
WA	27	
46086	2	
51745	2	
57185	23	

D2931 Bumper		Manufactured	No			150	Each	872.0000	2			
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Location	Loc Qty	Loc Code
ST504	872	
46064	872	

D3913-1 Rib		Manufactured	No			100	Each	0.0000	1			
----------------	--	--------------	----	--	--	-----	------	--------	---	--	--	--

B58124 ① M 10/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Date: 4/30/2010

Required Date: 5/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3913-15		Manufactured	No			100	Each	2.0000	1			
Wide Handle Plate												

B58125 ① SH 10/05/06

Location	Loc Qty	Loc Code
WA	2	
57079	2	

D3913-3		Manufactured	No			100	Each	7.0000	1			
Rib												

SH 10/05/06

Location	Loc Qty	Loc Code
WA	7	
57609	1	
58126	6	

①

D3913-7		Manufactured	No			100	Each	0.0000	2			
Rib												

B58127 ② SH 10/05/06

D3913-9		Manufactured	No			100	Each	1.0000	1			
Hinge Rib												

B58128 ① SH 10/05/06

Location	Loc Qty	Loc Code
WA	1	
57610	1	

D3916-041		Manufactured	No			100	Each	0.0000	2			
Rib Assembly												

B58357 ② SH 10/05/06

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 4/30/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D3916-5

Manufactured

No

100

Each

2.0000

3

Light Rib

Location

Loc Qty

Loc Code

WA

2

57023

2

D4016-1

Manufactured

No

100

Each

4.0000

3

Hinge Half, Base

Location

Loc Qty

Loc Code

ST109

4

57611

4

D4017-7

Manufactured

No

100

Each

0.0000

1

Rib

D4017-9

Manufactured

No

100

Each

0.0000

2

Rib

D4020-1

Manufactured

No

100

Each

0.0000

1

Mesh (350 Basket Long, Base)

D4020-11

Manufactured

No

100

Each

1.0000

2

End Mesh, Basket

Location

Loc Qty

Loc Code

WA

1

56990

1

Friday, April 30, 2010 1:01:01 PM

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Page 3

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Required Date: 5/21/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4021-1

Manufactured

No

100

Each

7.0000

3

Handle Plate

Location

Loc Qty

Loc Code

ST109

7

57086

7

D4021-5

Manufactured

No

150

Each

4.0000

2

Blanking Plate

Location

Loc Qty

Loc Code

ST109

4

57612

4

D4034-041

Manufactured

No

100

Each

4.0000

1

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

4

57988

4

D4034-043

Manufactured

No

100

Each

4.0000

1

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

4

58040

4

B58139 ③ SJ 10/05/06

EP 10/05/10
B58140

B57988 ① SJ 10/05/06

B58040 ① SJ 10/05/06

Friday, April 30, 2010 1:01:01 PM

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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chg qty's DD 10.04.12 verified by:EC


IPP Rev:B

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	1,891.000	2			

Location	Loc Qty	Loc Code
ST321	1891	
106375	3	
107939	888	
111636	1000	

MS21042L3  Nut		Purchased	No			150	Each	1,816.000	6			
---	--	-----------	----	--	--	-----	------	-----------	---	--	--	--

Location	Loc Qty	Loc Code
ST300	1816	
113537	20	
113644	796	
114523	1000	

NAS1149F0332P  WASHER		Purchased	No			150	Each	959.0000	12			
--	--	-----------	----	--	--	-----	------	----------	----	--	--	--

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

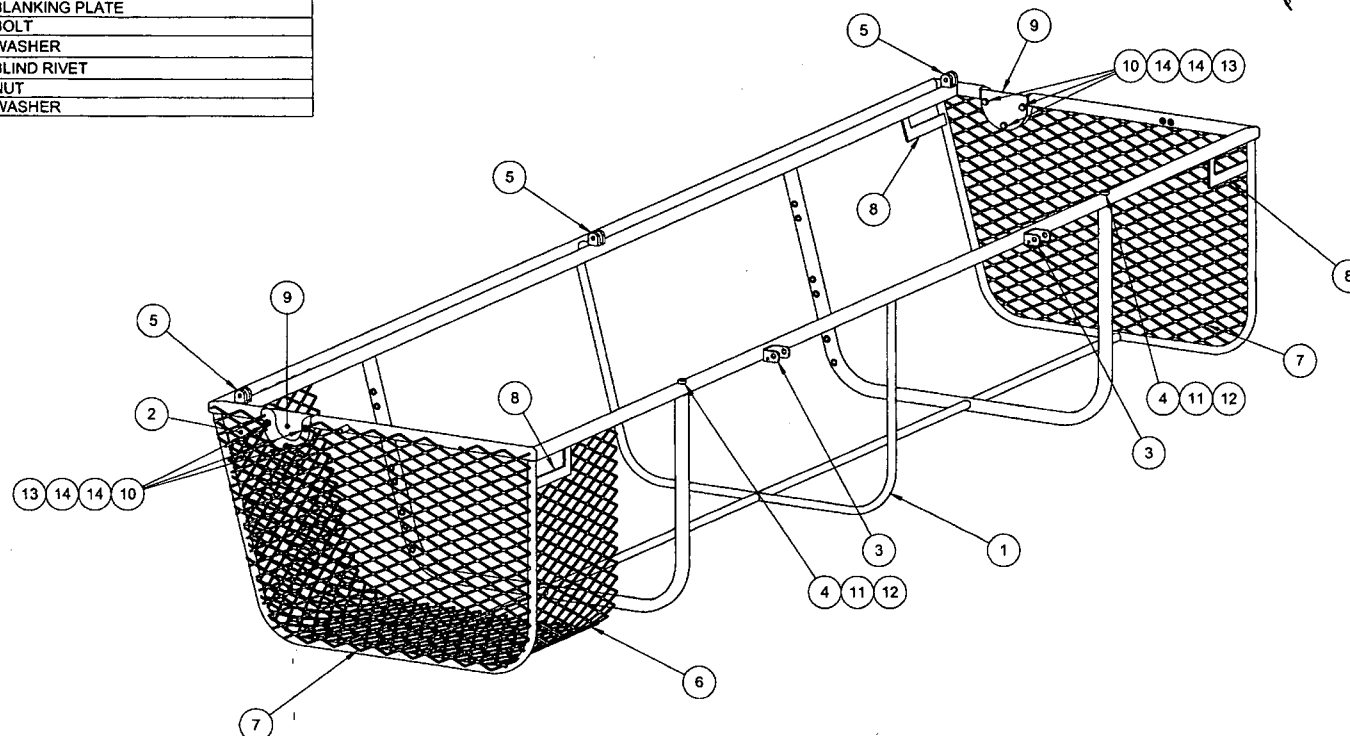
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

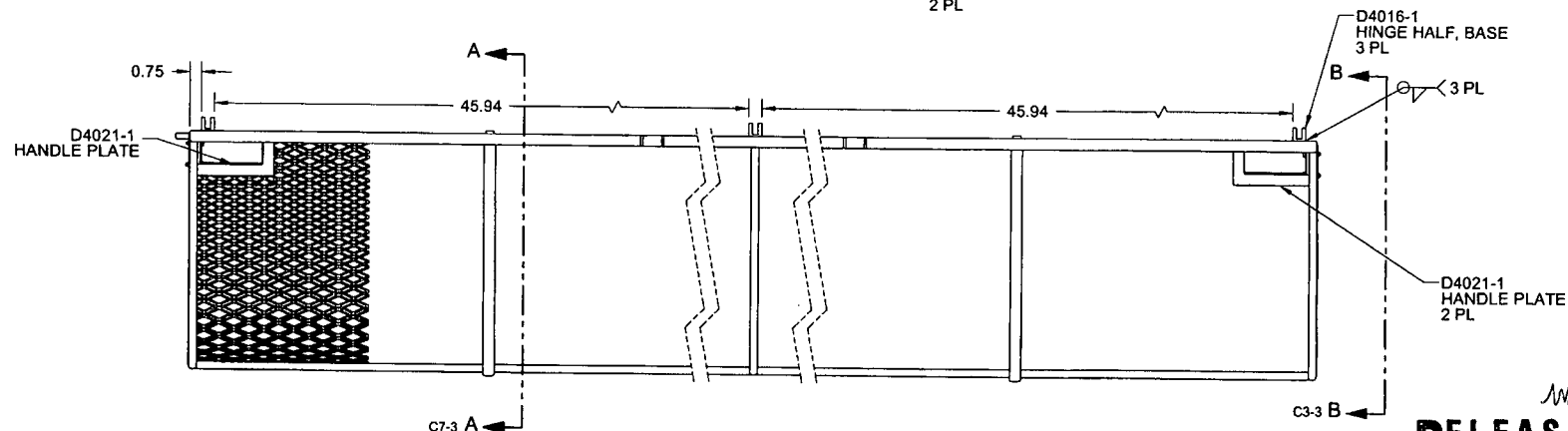
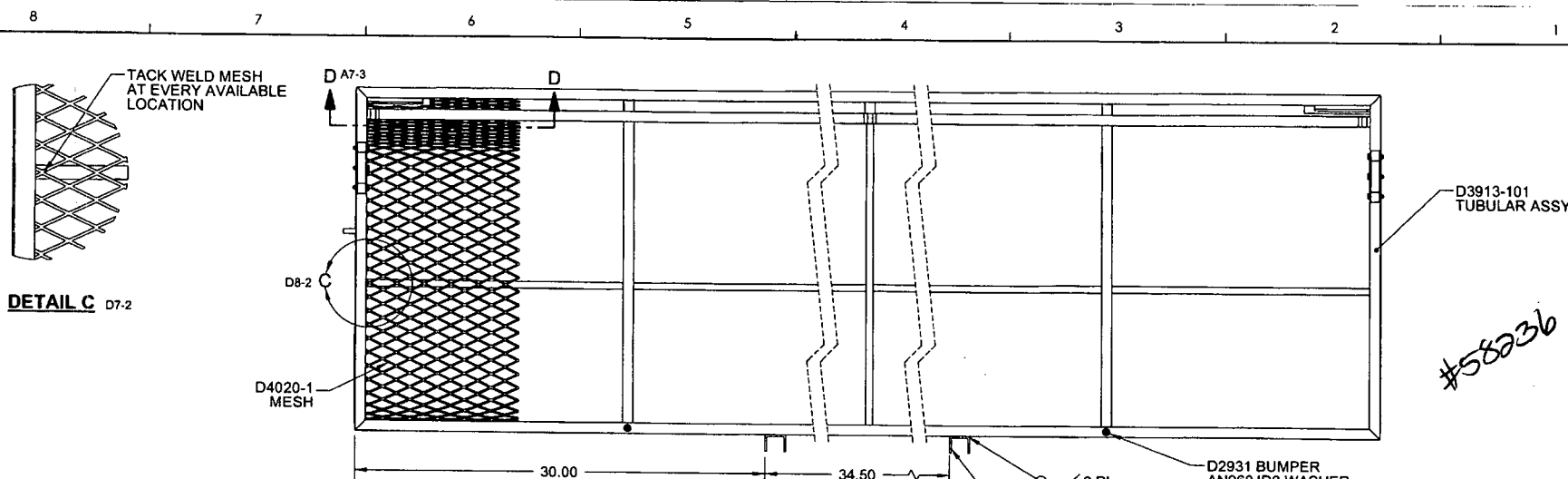
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3913

TITLE
LONG BASKET BASE ASSY (350) NTS

REV. A
SHEET 1 OF 6
SCALE

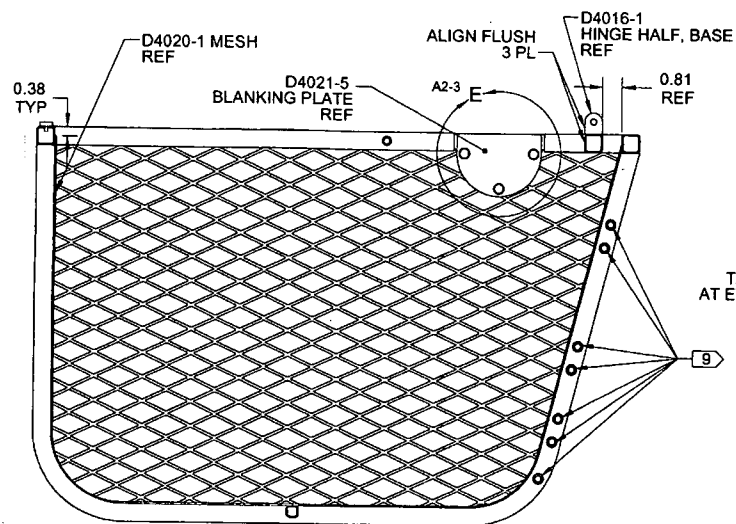
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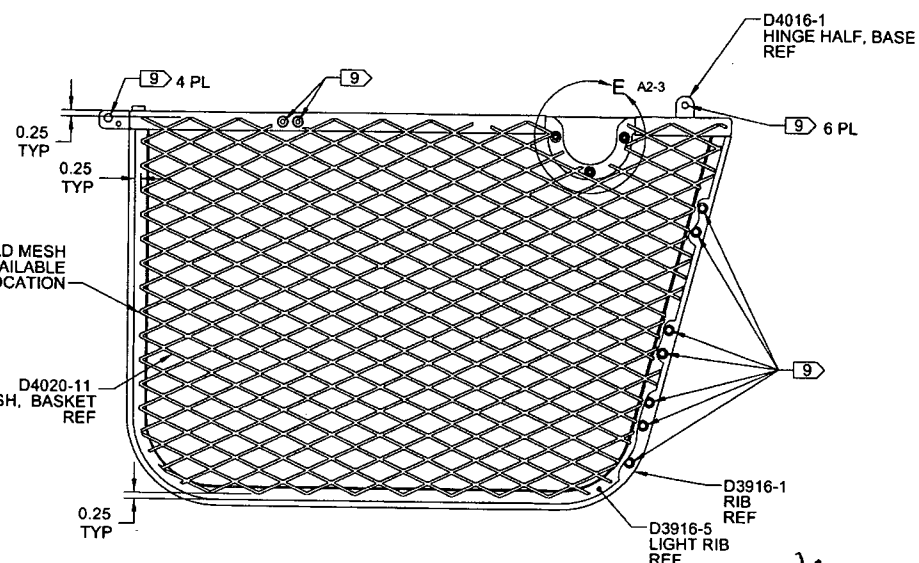
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

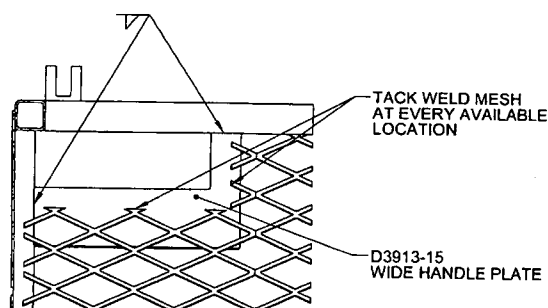
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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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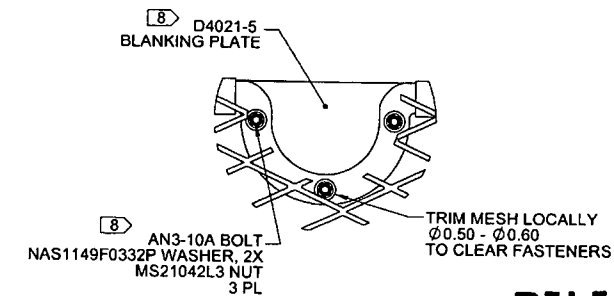
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

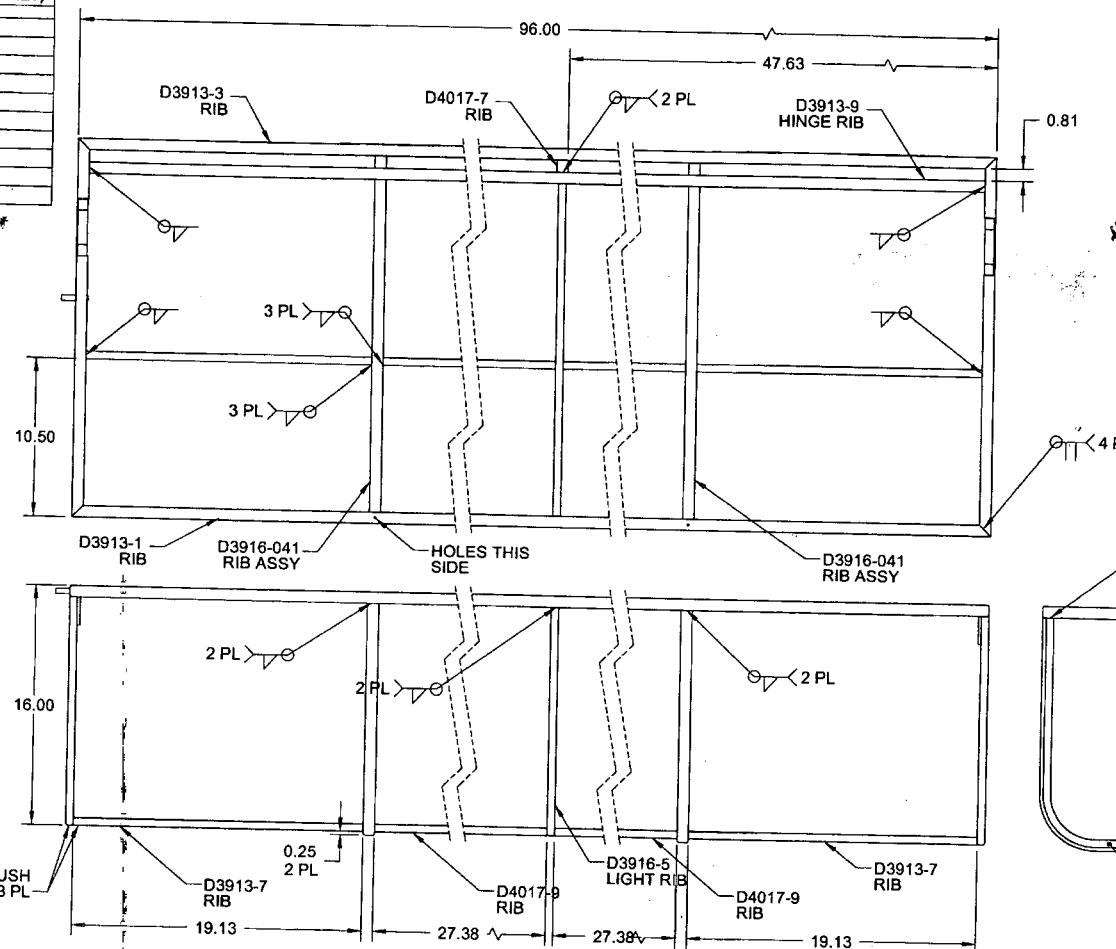


DETAIL E D2-3
D6-3

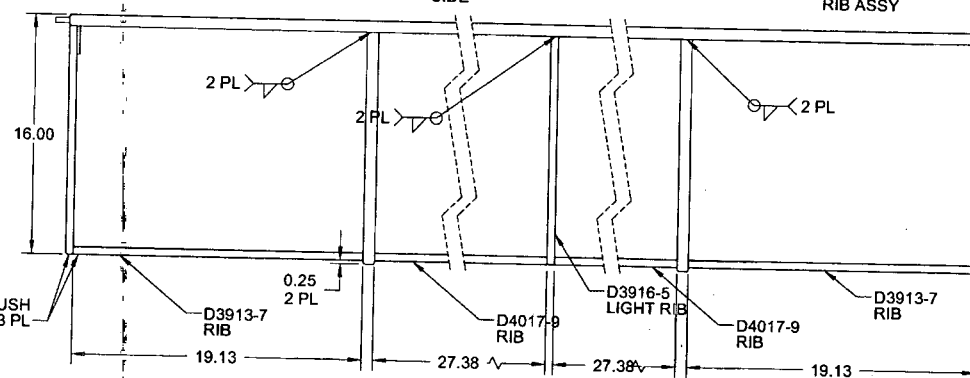
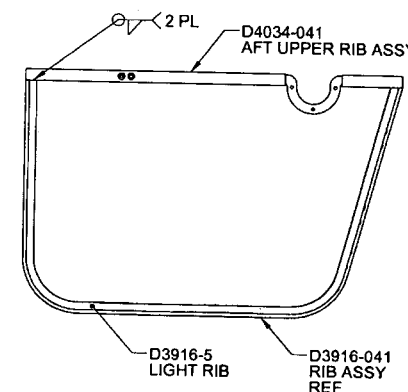
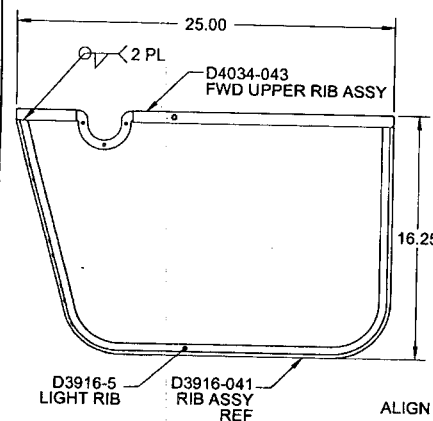
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-22

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



#58236



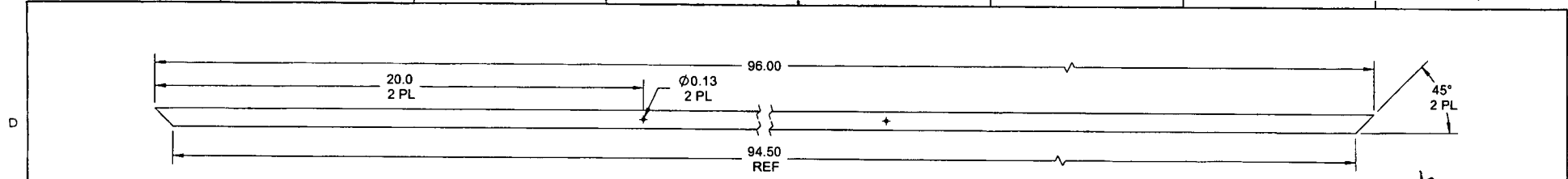
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

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2010-03-22

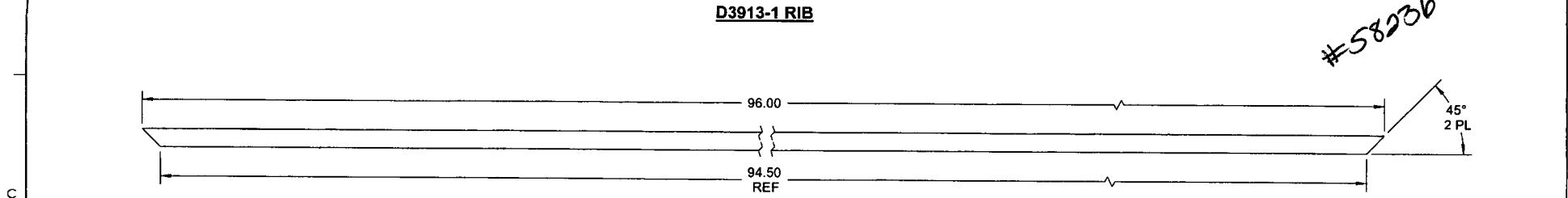
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

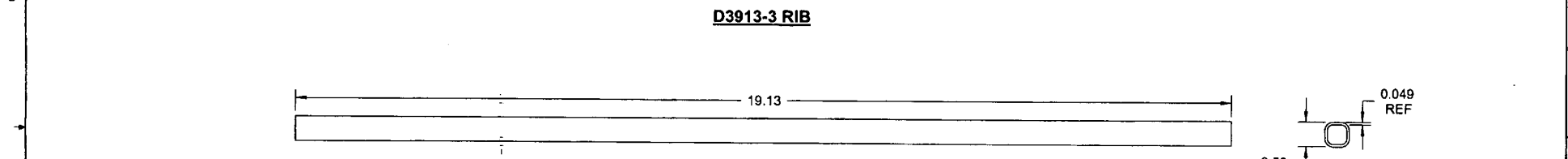


D3913-1 RIB

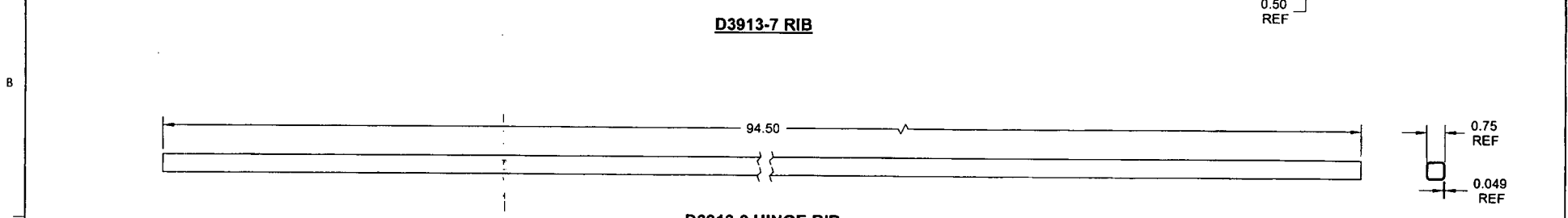
#58236



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB





NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

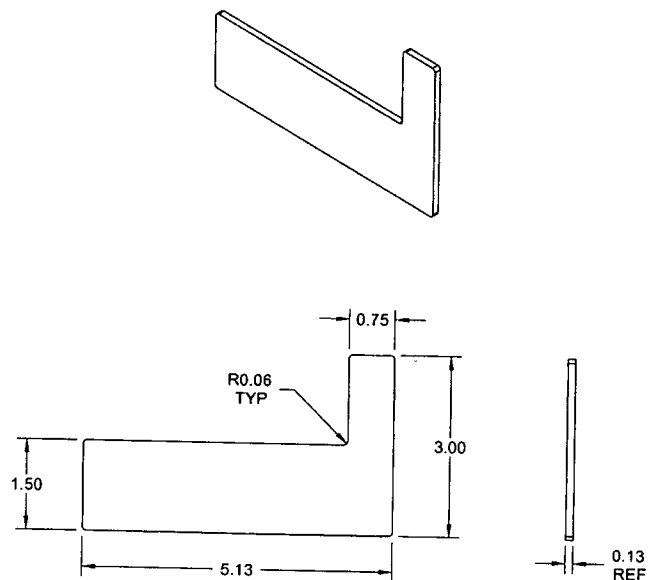
-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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8 7 6 5 4 3 2 1



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22
JWP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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